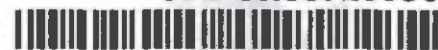




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D117-762-041
Job Sheet 203987



Part No: D117-762-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/2/19

Job Tracking No:

Due Date: 12/27/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV:C (ecn16-514)DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Skidtubes - 1	1 pcs	12/27/19		0.00	3.30	Skidtubes - 1		DQ
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	Skidtubes - 2 - B4B	1 pcs	12/27/19		0.00	1.58	Skidtubes - 1 - B4B		AR
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
150	QC 10	1 pcs	12/27/19		0.00	0.00	QC 10 - 10		DAS DEC 10 2019 68 9-89
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
160	QC 5	1 pcs	12/27/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 2		

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					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	DEC 10 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	12/27/19	0.00 0.97		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	★ DEC 10 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
180 QC 7	1 pcs	12/27/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					Plex 12/2/19 8:18 AM Dart.lajeunesse.marie	

				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	AD U
190 Skidtubes - 3 - B4B	1 pcs	12/27/19	0.00 5.82	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 10	1 pcs	12/27/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	DAS DEC 17 2019 68
				QC 5 - 10	9-89
				QC 5 - 12	
210 QC 5	1 pcs	12/27/19	0.00 0.00	QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS DEC 17 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
215 Handfinish - 2-1 Pressure-	1	12/27/19	0.00 0.97	Handfinish - 2 - 1 -	

B4B	pcs				B4B	
					Handfinish - 2 - 2 - B4B	DEC 17 2019
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
220 Powdercoat - 1 White GI(A)-B4B	1 pcs	12/27/19	0.00	0.26	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	BEB 19-12-20
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
230 QC 3	1 pcs	12/27/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	DEC 20 2019 68
					QC 3 - 9	9-89
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	12/27/19	0.00	0.97	Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	BEB 19-12-23
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	

				Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	12/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS DEC 23 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
270 Packaging 3-1 - Stock - B4B	1 pcs	12/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	12/27/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	DEC 24 2019

N/A
-04

Part Op 130 - Skidtubes-1 (Skidtubes) 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN

Descriptions: AFT CAP HOLE TO .187" *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16 cleco in Ground wire hole, then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B, locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill. 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open holes of section G-G to finishes size.

140 - Skidtubes-1 (Skidtubes) 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD

Batch: 138989/13919 2-Grind flush

150 - QC10 (QC10- Inspect visual per QSI004- ground welds)

160 - QC5 (QC5- Inspect part completeness to step on W/O)

170 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

180 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

190 - Skidtubes-1 (Skidtubes) ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E and G-G.***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R

241 Sika Flex Batch: 5231015 Exp Date: 05/18/2020 6- Swage x-bolt spacer as per dwg and Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD

Batch: 138989/13919 8-Grind welds flush

200 - QC10 (QC10- Inspect visual per QSI004- ground welds)

210 - (QC5- Inspect part completeness to step on W/O)

215 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch-up alodine as per QSI

220 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME 8:55 OVEN TEMPERATURE: 320° FINISH TIME: 9:25 12/18/16.

230 - (QC3- Inspect Part Finish)

250 - HandFinish4 (Assemble as per dwg) 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex Batch: 5231095 Exp Date: 2/1/03. 3-Install Wearplates as per Dwg D3582 ,

Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

260 - (QC5- Inspect part completeness to step on W/O)

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

275 - (Document Control) Photocopy bluefile & type labels per PPP D117-762-041 CHG003

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 pcs (1 ea)	130-Skidtubes - 1	5221590
D5520-1	Doubler	2 pcs (2 ea)	130-Skidtubes - 1	5218923
D2964	Cap	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	5176502
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes - 3 - B4B	5231355
D2971	Cross Bolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5213154
D3584-1	Web	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5225195
D3662-1	Crossbolt Spacer	3 pcs (3 ea)	190-Skidtubes - 3 - B4B	5214249
D3662-3	Crossbolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5173690
D5304-1	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5216553
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-Handfinish - 4-1-Assembly-B4B	5057250-1
ALS4-428-165	Insert	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5147561
AN3-5A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5216385
AN3C4A	Bolt	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5239244
AN4-4A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5193116
D2965	Cap	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5166570
D3508-11	Wearplate Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172298-1
D3508-13	Wearplate Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5240834
D3508-3	Wearplate Fwd Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172576
D3508-9	Wearplate Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172977
D3558-11	Gasket Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210680
D3558-13	Gasket Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5224210
D3558-3	Gasket Center Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210684
D3558-9	Gasket Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210682
NAS1149C0332R	Washer (AN960C10L)	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5233308
NAS1149D0332J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5178378
NAS1149D0416J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	51131511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-Skidtubes - 1	D3582-1-BENT	1	4	0
	D5520-1	2	6	0
	D2964	1	17	0
140-Skidtubes - 2 - B4B	CR3212-5-05	68	1,940	0
	D2971	1	57	0
	D3584-1	1	3	0
190-Skidtubes - 3 - B4B	D3662-1	3	101	0
	D3662-3	1	30	0
	D5304-1	2	15	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	36	3,790	0
	ALS4-428-165	2	52	0
	AN3-5A	2	199	0
	AN3C4A	28	962	0
	AN4-4A	2	24	0
	D2965	1	30	0
	D3508-11	1	5	0
	D3508-13	1	0	0
	D3508-3	1	9	0
	D3508-9	1	6	0
	D3558-11	1	5	0
	D3558-13	1	11	0
	D3558-3	1	6	0
	D3558-9	1	6	0
	NAS1149C0332R	28	4,607	0
	NAS1149D0332J	2	2,877	0
	NAS1149D0416J	2	1,626	0

Part Specifications

Specifications could not be found.

ITEM	Qty	Part Number	Description
	X	D3882-041	SKIDTUBE ASSEMBLY
1	1	D2882-160	EXTRUSION
2	1	D2884	CAP
3	1	D2886	CAP
4	1	D2871	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-8	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3559-3	GASKET
10	1	D3559-9	GASKET
11	1	D3559-11	GASKET
12	1	D3559-13	GASKET
13	1	D3594-1	WEB
14	3	D3882-1	CROSS BOLT SPACER
15	1	D3882-3	CROSS BOLT SPACER
16	2	D5304-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1148C0332R	WASHER (AN660C10L)
22	2	NAS1148C0332J	WASHER (AN660JD10L)
23	2	NAS1148D0416J	WASHER (AN660JD416L)
24	38	AELB-1032-130	INSERT
25	2	ALST-428-185	INSERT
26	88	CR3212-5-05	CSK RIVET, CHERRY MAX

- NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3884-1 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 18.2 lbs
8) WELDING: PER DART QSI 004.
9) INSERT D3884-1 WEB TO LOCATION SHOWN OFF APT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281 ADHESIVE PER DART QSI 016 AFTER BENDING.
10) USE DART DRILL TEMPLATE DTR900 TO LOCATE AND DRILL .80/287 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELB-1032-130 PER SECTION 9-3 (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/281.
11) DO NOT INSTALL AN3C4A BOLTS AND NAS1148C0332R WASHERS IN INDICATED LOCATIONS
12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5820-1 DOUBLER AND DRILL .80/181 THRU SKIDTUBE AND DOUBLER USING DTT10308. COUNTERSINK .80/286 x 100' (34 PL) PER DOUBLER AND INSTALL EACH D5820-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

RELEASED
2017-10-11
EW17-547

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WITHOUT NOTICE
WORK ORDER
NO. 203987 MJS
19-1202

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 26 AND NOTE 12-13. .00/187 HOLE WAS .80/75. ADD SHT 3. ADD DETAIL J. SECTION F-F ADD D5820-1. SCALE ON VIEWS WAS 3X.		AJS	17.03.27
D	D3804-1 WAS D2873; REVISE BOM & SECTION F-F & SECTION NOTES (ZN BT-3, AS-3; REF NCT10-5160) NOTES SHT 1		RF	17.01.09
C	D3482 PLUG ASSEMBLIES REMOVED. REFORMAT		AP	15.11.02
B	29.88 WAS 29.87 (ZN D2-1). INCORPORATED DEO D3552A-1 (ZN D5-1). FORMAT TO CURRENT STD		RF	15.02.20
A	NEW ISSUE		PH	07.06.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH		DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	AJS			
CHECKED	<i>ms</i>			
MFG. APPR.	<i>DJ</i>			
APPROVED	<i>AP</i>			
DE APPR.			REV. E	
DATE	17.03.27		SHEET 1 OF 4	
		TITLE		SCALE
		BK 117 SKIDTUBE ASSEMBLY		NTS
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DETAIL C
SCALE 4X



SECTION D-D
SCALE 4X



SECTION E-E
SCALE 4X

- SECTION D-D NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

- PERFORM THE FOLLOWING:**
- 1. CHAMFER HOLE 0.030 x 45°**
 - 2. INSERT D2871 SPACER**
 - 3. WELD INTO PLACE AND GRIND FLUSH**
 - 4. PASS Ø0.780 DRILL TO REMOVE SPILL OVER**

- SECTION E-E NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
A QUALIFIED LION E 0.020 x .45"

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3882-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS 50.872 DRILL TO REMOVE SPILL OVER



917



10

- OTE8**
2 PL

- SECTION F-F NOTES**
AFTER BENDING AND DRILLING ASSY
PERFORM THE FOLLOWING:
1. INSERT D6304-1 SPACER
 2. SWAGE TO Ø0.585 ±0.005/0.000
DEEP PER QSI 002
 3. OPEN THRU HOLE TO Ø0.625
 4. GRIND FLUSH

- ## NOTES

- SECTION G-G NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3682-1 SPACER (3 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.515 DRILL TO REMOVE SPILL

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- ## NOTES

- SECTION 9-3 NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3662-1 SPACER (3 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	EUGENE, OR	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
INFO. APPR.	<i>[Signature]</i>	D3582	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BK 117 SKIDTUBE ASSEMBLY	NT3
DATE	17.03.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	

RELEASED
2017-08-11

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Material let ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																																			
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)																																			
Description Work Order Deviation				Disposition																																			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="1"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table> Other/Details: _____								☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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				Completed By _____				Lead hand / Supervisor _____																															
				QC / QA Coordinator _____																																			

Change Record

PAGE 1 OF 1

Part Number: D117-762-041Description: REPLACEMENT SKIDTUBE[illegible]